

BLUE

Friday, 13/06/2008 1:33:24 PM  
Linda Lacelle

# Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	HELI ACESS STEP RH
<b>Job Number</b> :	39838	<b>Part Number</b> :	D206628022BL
<b>Estimate Number</b> :	11764	<b>Drawing Number</b> :	BLUE
<b>P.O. Number</b> :		<b>Project Number</b> :	N/A
<b>This Issue</b> :	13/06/2008	<b>Drawing Revision</b> :	N/A
<b>Prsht Rev.</b> :	NC	<b>Material</b> :	
<b>First Issue</b> :	/ /	<b>Due Date</b> :	30/06/2008
<b>Previous Run</b> :	39866	<b>Qty:</b>	1
<b>Written By</b> :		<b>Um:</b>	Each
<b>Checked &amp; Approved By</b> :			
<b>Comment</b> :	Est Rev:D as per ECN 766 JLM Est Rev:E as per ecn 1118 DD verified by:EC		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	DC	DOCUMENT CONTROL
-----	----	------------------



**Comment:** DOCUMENT CONTROL JUD 08.6.16 003  
 Photocopy blue file and type labels as per PPP D206-628-022 CHG 002 08/06/06

2.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



**Comment:** PACKAGING RESOURCE #1  
 Pick Packing Kit

3.0	39838A	206L /407 STEP ASSY, RH
-----	--------	-------------------------



**Comment:** Sub-Component Step Assembly  
 1 x D2724-042 Batch 39838A

4.0	D2732030	Rubber Cushion
-----	----------	----------------



**Comment:** Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)  
 Rubber Cushion  
 batch 32632

5.0	AN414A	Bolt
-----	--------	------



**Comment:** Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)  
 Bolt  
 batch M107534

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI ACESS STEP RH

Job Number: 39838

Part Number: D206628022BL

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D27317

Mounting Lug



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch  
4 D2731-7 Mounting Lug ~~3462~~ (BLUE)

~~35603~~

B34/62

7.0

D3394043

Lug Assembly



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch  
4 D3394-043 LUG ASS.Y ~~35603~~ (BLUE)

8.0

AN415A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number Description Batch  
8 AN4-15A Bolt M104072

9.0

AN960JD416

Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number Description Batch  
12 AN960JD416 Washer M107939

10.0

MS21042L4

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number Description Batch  
12 MS21042L4 Nut (or MS21042-4) M107478

11.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

08/06/26 (+0)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI ACESS STEP RH

Job Number: 39838

Part Number: D206628022BL

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-628-022

Location: \_\_\_\_\_

PPP Rev: \_\_\_\_\_

Revs

JS 08/06/26 (xy)

13.0

QC21

FINAL INSPECTION/W/O RELEASE



08/06/26 JF

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-06-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

BLUE

Up of 07

Dart Aerospace Ltd.

Date: Friday, 13/06/2008 1:33:33 PM  
User: Linda Lacelle

# Process Sheet

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b>	: 206L /407 STEP ASSY, RH
<b>Job Number</b>	: 39838A		
<b>Estimate Number</b>	: 11703		
<b>P.O. Number</b>	:	<b>Part Number</b>	: D2724042
<b>This Issue</b>	: 13/06/2008	<b>S.O. No.</b>	:
<b>Prsht Rev.</b>	: NC	<b>Drawing Number</b>	: D2724 REV C
<b>First Issue</b>	: / /	<b>Project Number</b>	: N/A
<b>Previous Run</b>	: 39866A	<b>Drawing Revision</b>	: C
	<b>Type</b> : LARGE FAB ASSY	<b>Material</b>	:
<b>Written By</b>	:	<b>Due Date</b>	: 30/06/2008
<b>Checked &amp; Approved By</b>	:	<b>Qty:</b>	1 Um: Each
<b>Comment</b>	: Est Rev:E As Per Ecn 766 06-01-06 JLM		

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
----------------	------------------------------	----------------------

1.0	D2622120C	Step Extrusion
-----	-----------	----------------



**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Qty	Part #	Description	Batch:
1	D2622-120C	Extrusion	37754

Check Material for any Dents or Defects

SAN 08/06/16 ①

2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
-----	-------------	------------------------------

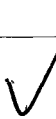


**Comment:** LARGE FABRICATION RESOURCE 1

Cut D2724-2 using D2622 extrusion as per Dwg D2724  
Deburr and bevel ends for welding

SAN 08/06/16 ②

3.0	D2734	Step End Plate
-----	-------	----------------



**Comment:** Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

206 Step Endplate  
Pick:  
Qty Part Number Description Batch  
2 D2734 End Cap 836520

08-06-16

4.0	D34581	Step Mounting Plate
-----	--------	---------------------



**Comment:** Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:  
Qty Part Number Description Batch  
2 D3458-1 Plate 835145

08-06-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Date: Friday, 13/06/2008 1:33:33 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L /407 STEP ASSY, RH

Job Number: 39838A

Part Number: D2724042

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D34583

Step Mounting Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch  
2 D3458-3 Plate 336409

08.06.16

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld end cap and lugs as per Dwg D2724 using Jig DT followed by Jig

DT (One End Only)

A/R AL ROD Batch: M106834  
M107678

Grind end cap welds flush

08.06.16

08.06.16

7.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

08.06.17

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08.06.17

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

08/06/18

1 X RH

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08.06.18

11.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Inspect for foreign object per QSI 024

08.06.18

Date: Friday, 13/06/2008 1:33:33 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L /407 STEP ASSY, RH

Job Number: 39838A

Part Number: D2724042

Job Number:



Seq. #:

Machine Or Operation:

Description :

Weld Remaining end cap as per Dwg D2724 using Jig DT followed by Jig

DT

A/R AL ROD

Batch:

*m106834*

Grind end plate flush.

*08.06.18*

12.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

*08.06.19*

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*08.06.19 + (RH)*

14.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

*1x RH*

Touch up Alodine

*m. 08/06/21*

15.0

SPRAY PAINTING

SPRAY PAINTING



Comment: -PRIME

-SPRAY PAINT BLUE DELFLEET

-CLEAR DELFLEET

*08-06-25*

16.0

QC14

INSPECT SPRAY PAINT



Comment: INSPECT SPRAY PAINT

*ml 08.06.26*

*1*

17.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: Wing Walk as per Dwg D2724 and QSI 00 5.4.4

*m107892*

*08/06/26*

18.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*08/06/26*

Date: Friday, 13/06/2008 1:33:33 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L /407 STEP ASSY, RH

Job Number: 39838A

Part Number: D2724042

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

PPP 39838

PC 8/8/28

(C)

20.0

QC21

FINAL INSPECTION/W/O RELEASE



08/06/26

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-06-26

**DART**

RELEASED

05.11.14

NOTE: ALL WELDS SHALL  
BE 100% VISUALLY  
INSPECTED BY A QUALIFIED  
INSPECTOR PER DART  
QSI 004

APPLY BLACK  
ANTI-SKID ON  
TOP SURFACE  
TO BOTTOM  
OF TOP RADIUS

REFER TO STEP  
END DETAIL

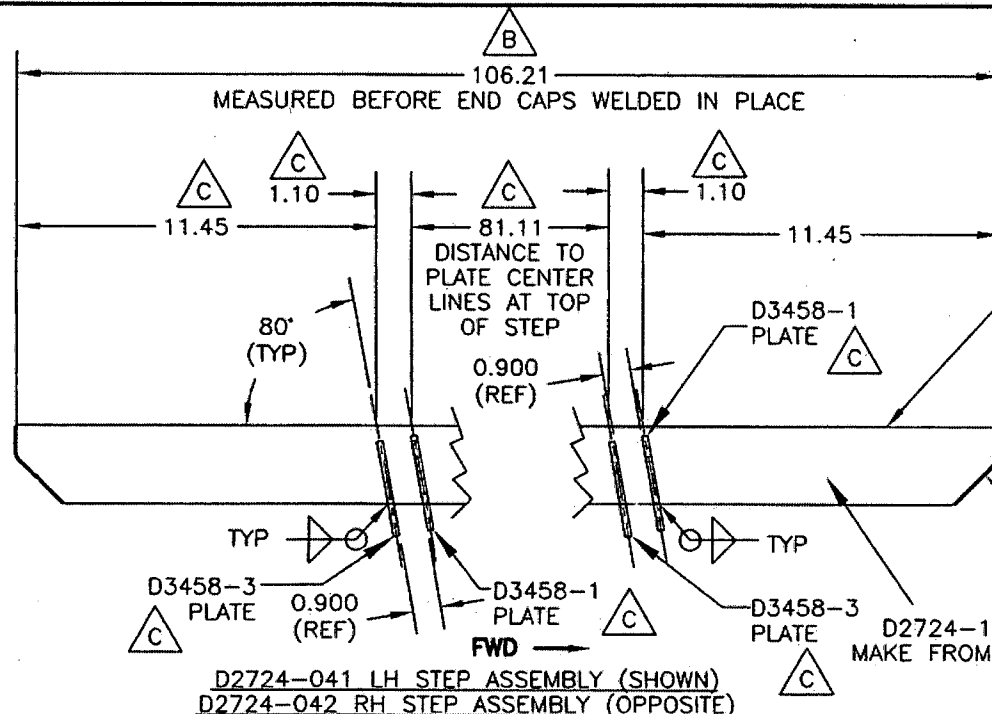
D2724-1  
MAKE FROM EXTRUSION D2622-107

ROUND CORNER OF EXTRUSION TO  
MATCH BEND RADIUS OF END PLATE

D2734 END PLATE

TYPICAL STEP END DETAIL  
NOT TO SCALE

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 5183314



**D2721-041/-042 STEP ASSEMBLY PARTS LIST**

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D2724-041	LH STEP ASSEMBLY
	X	D2724-042	RH STEP ASSEMBLY
1	1	D2622-107	EXTRUSION
2	2	D2734	END PLATE
2	2	D3458-1	PLATE
2	2	D3458-3	PLATE

**D2724-041/-042 STEP ASSEMBLY**

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3  
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

Copyright © 2005 by DART AEROSPACE USA, INC.

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
KE	PH	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
		D2724
DATE	TITLE	REV. C
05.09.19	206L/407 STEP ASSEMBLY	SHEET 1 OF 1
A	97.12.04	NEW ISSUE
B	98.10.19	UPDATED WELD DETAIL REVISED TOLERANCES
C	05.09.19	RE-DESIGN, ADD D3458-1/-3
		SCALE NTS